

Date: Wednesday, 10/11/2006 11:12:32 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28926
 Estimate Number : 10793
 P.O. Number : N/A
 This Issue : 10/11/2006 S.Q. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LARGE FAB ASSY
 Previous Run : 24868
 Written By : JA 06 10 11
 Checked & Approved By : JA 06 10 11
 Comment : Est Rev: A 05.10.14 New issue KJ/EC

Drawing Name : TOW RING
 Part Number : D3407043
 Drawing Number : D3407 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : N/A
 Due Date : 10/30/2006

Qty: 22 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D34073	Stem



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3407-3

Stem

328745 324587

CPL 07.01.02

(22)

2.0	D34075	Ring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3407-5

Ring

328333

CPL 07.01.02

(22)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld D3407-3/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004

A/R TIG174 ROD

Batch: M18774

CPL 07.01.02

(22)

4.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

12/07/01/03 (22)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

12/07/01/03 (22)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/01/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 11:12:32 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 28926

Part Number: D3407043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M102391



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask Threaded Section

FL/a.m 07/31/05 (22)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/01/08 (22)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5432

PC 7/01/08 (22)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PC 07/01/08

Job Completion



u 07/01/08

Dart Aerospace Ltd

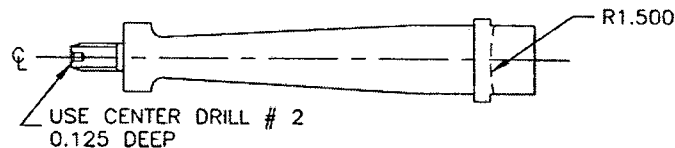
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

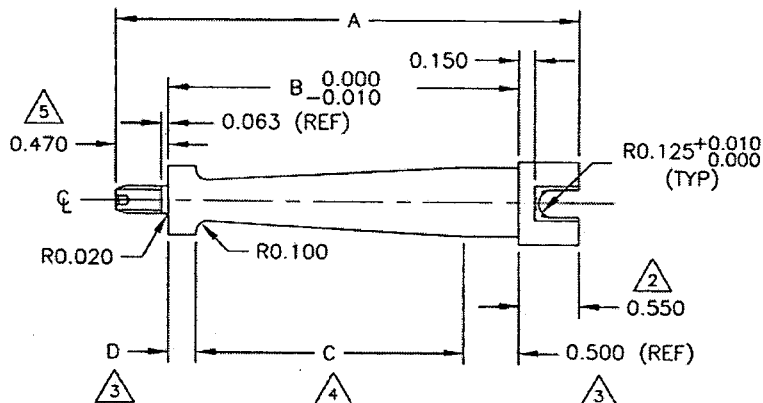
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED

05.09.12



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

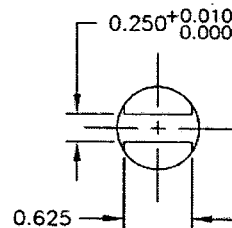
D3407-1/-3 STEM

D3407-1 AND D3407-3 STEM:

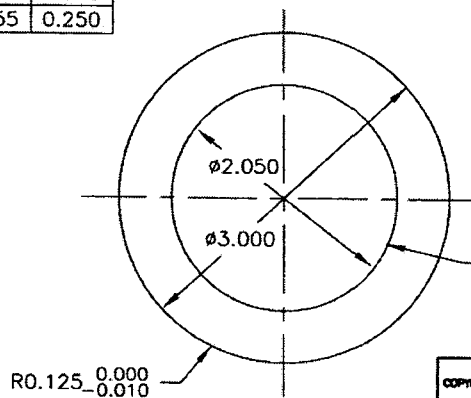
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D. TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3407-5 RING:

- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



USE D3407-1 STEM FOR -041
USE D3407-3 STEM FOR -043



D3407-5 RING

DEBURR 0.010 TO 0.020

D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	#	APPROVED #
DATE	05.09.09	TOW RING
DRAWING NO.	D3407	REV. 0
TITLE	TOW RING	SHEET 1 OF 1
SCALE	1:1	

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